

Work Order ID 78259

January-03-12 1:52:52 PM

78259

Jan 11th

Page 1

Item ID: D3230-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Wedge Assembly
 Start Date: 03/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/03 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3230	Rev C								

110 0.00

110

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230
 2- Drill and c'sink holes
 3- cut mesh as per dwg
 4 -Deburr & Remove all Markings From Material
 5-Weld bushings and fabricate basket wedge assembly as per D3230
 LOOK AT DWG FRONT MESH MUST BE WELDED INSIDE
 A/R SS ROD Batch: 117384

PL 12-01-09

1x

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Quality Control

Memo

0.00

12-01-09

1 0

BE 12-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		81260109		(78)			

140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo 1ST COAT: START TIME: 2:45 OVEN TEMPERATURE: 400°F FINISH TIME: 3:15 **** if necessary**** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00
---	---	--------------

muax80

IXD M-L 12/01/09

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Item ID: D3230-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Wedge Assembly

Start Date: 03/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

12 01 09 (1)

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

PPP
78259

12/01/11 (1)

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/11/11

MF
12-01-11

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Picklist Print

January-03-12 1:52:57 PM

Page 1

Work Order ID: 78259

78259

Parent Item: D3230-041

D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 03/01/2012

Required Date: 10/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-3 *D2232-3* Basket Hinge		Manufactured	No			110	Each	10.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		10							
				75581		10				2			
D2327-3 *D2327-3* Spacer Bushing		Manufactured	No			110	Each	43.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		43							
				74782		19				2			
				75564		4							
				77229		20							
D3759-1 *D3759-1* Bushing		Manufactured	No			110	Each	263.0000	5	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		263							
				66489		2							
				74443		60				5			
				74783		201							

PL 12.01.06

PL 12.01.06

PL 12.01.06

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Picklist Print

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Page 2

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Parent Item: D3230-041

D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 03/01/2012

Required Date: 10/01/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

110 sf

595.5774

5.15

5.421053

M304EX0 75-16F

Expanded Metal Flat SS

**

Pl 12.01.06

Location	Loc Qty	Loc Code
WA	0.0001156	
119180	0.0001156	
WA035	595.577296	
117197	102.9036	
117896	38.3264	
118153	76.8473	
118248	3.0983	
118597	21.06788	
118955	82.17	
119180	64.537916	
119729	206.6259	

M304TS0.750W.065

Purchased

No

110 f

186.7507

25.2966

26.628

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

Pl 12.01.05

Location	Loc Qty	Loc Code
MAT018	165.0864785	
117636	67.9987	
118773	97.0877785	
WA007	15.5974906	
116267	14.628472	
116763	0.9690186	
WA035	6.0667	
118181	6.0667	

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Shop Packet Print

Page 2

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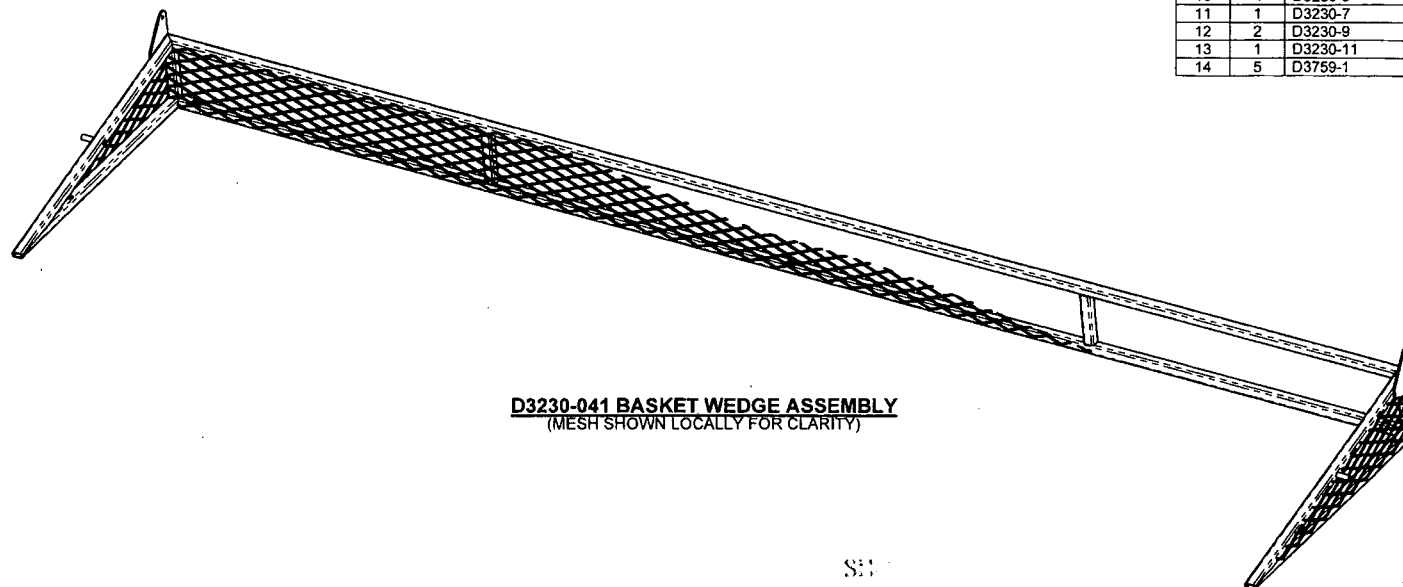
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3230-041	BASKET WEDGE ASSEMBLY
3	1	D2221-1	RIB
4	2	D2232-3	BASKET HINGE
5	2	D2327-3	SPACER BUSHING
6	1	D3230-1	RIB
7	1	D3230-2	RIB
8	1	D3230-3	RIB
9	1	D3230-4	RIB
10	4	D3230-5	RIB
11	1	D3230-7	RIB
12	2	D3230-9	SIDE MESH
13	1	D3230-11	FRONT MESH
14	5	D3759-1	BUSHING



D3230-041 BASKET WEDGE ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

SEE
FOR
EVALUATION
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK

NO 78259 M.L.J
12/01/03

RELEASED
09.01.19
PER ECN 09-534

C	REDESIGN (SEE NCR 09-010); REFORMAT DRAWING TO CURRENT STANDARDS	MB	09.01.27
B	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	CB	05.11.10
A	NEW ISSUE	CP	03.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3230	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3230-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 19.8 lbs
 - 8) WELDING: PER DART QSI 004

W/O:		WORK ORDER CHANGES					
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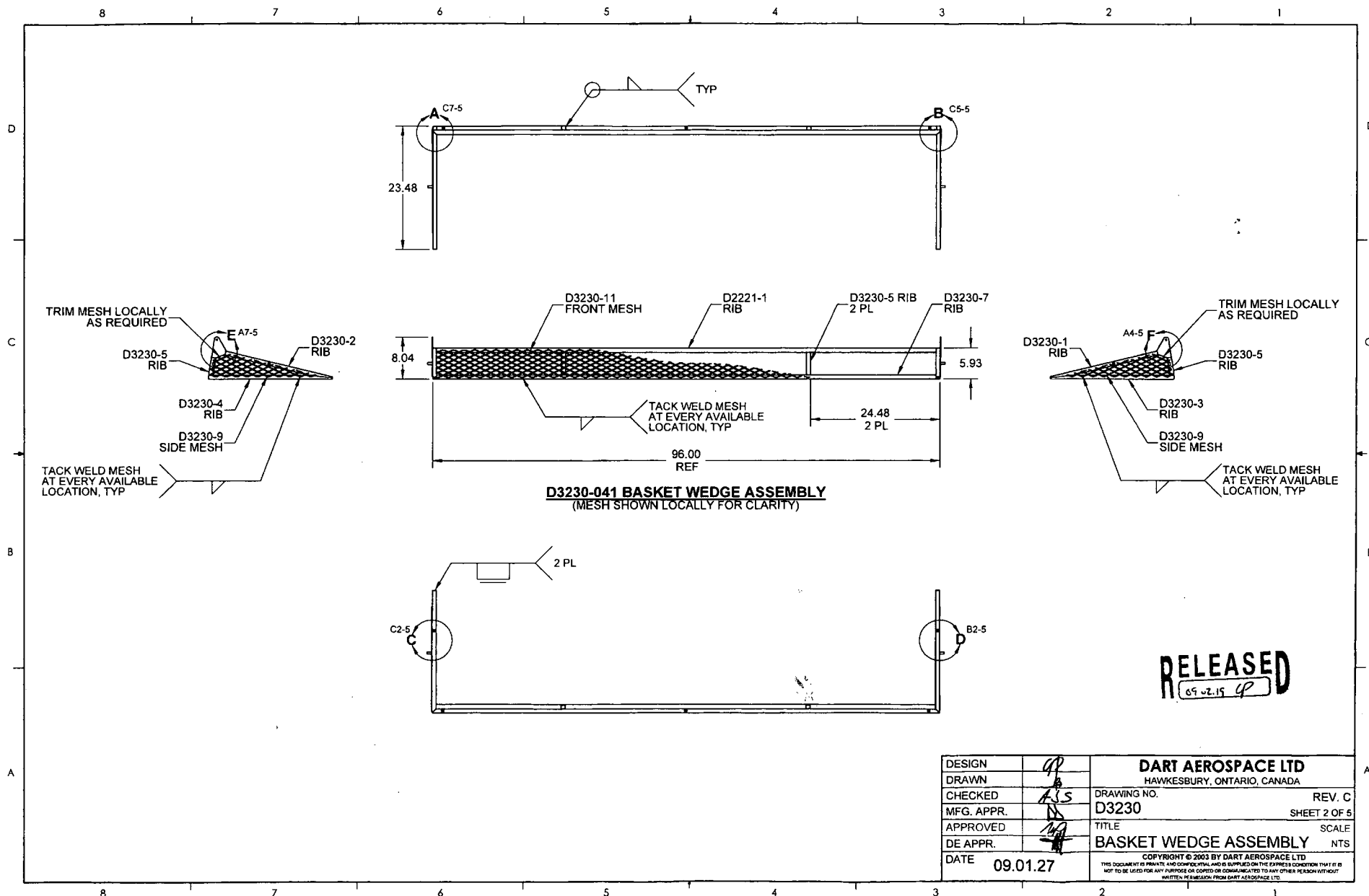
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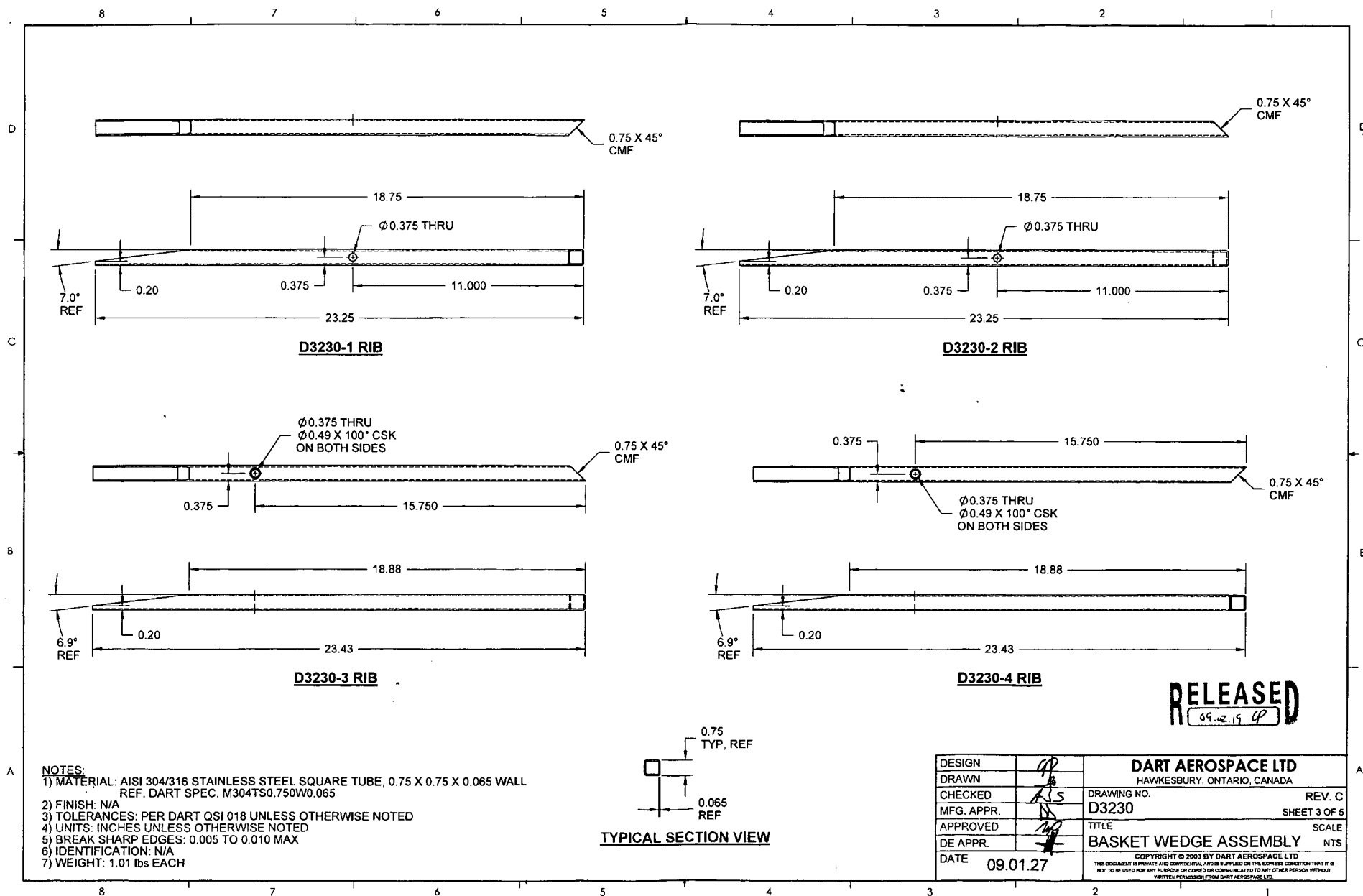
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NOTE: Date & initial all entries

78259



RELEASED
09-02-19 4P

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS	DRAWING NO.	REV. C
CHECKED	AS	D3230	SHEET 3 OF 5
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	BASKET WEDGE ASSEMBLY	NTS
DE APPR.	AS	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.01.27		

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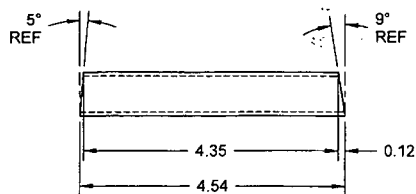
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

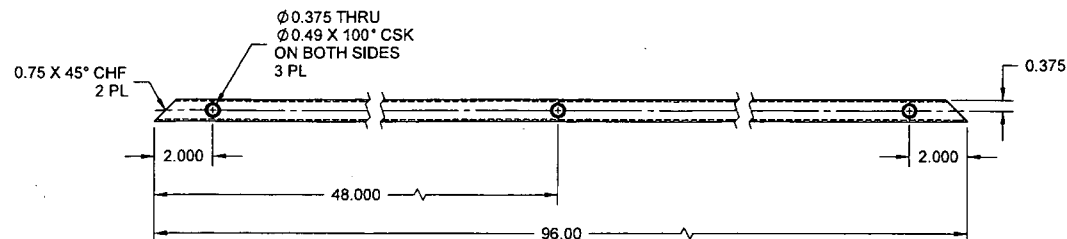
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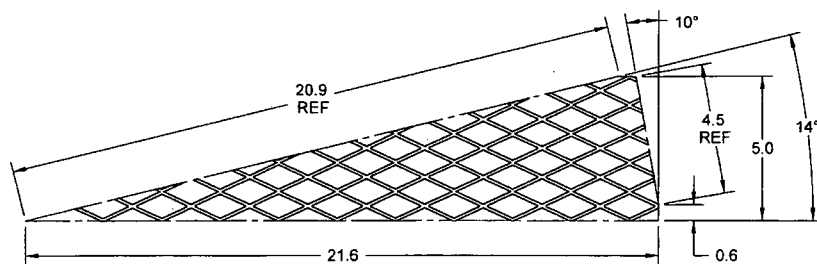
70259



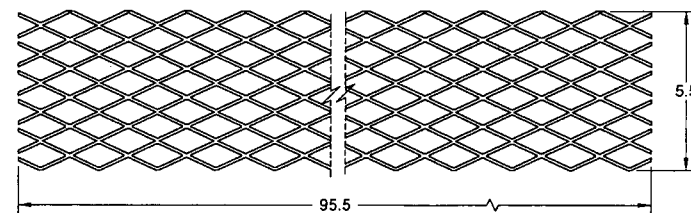
D3230-5 RIB



D3230-7 RIB



D3230-9 SIDE MESH



D3230-11 FRONT MESH

NOTES:

1) MATERIAL:

D3230-5/-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
D3230-9/-11: 3/4-16F EXPANDED STAINLESS STEEL
REF. DART SPEC. M304EX0.75-16F

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

**7) WEIGHT: D3230-5 = 0.21 lbs; D3230-7 = 4.55 lbs
D3230-9 = 0.20 lbs; D3230-11 = lbs**

RELEASED
09.02.19

DESIGN	42	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS		DRAWING NO. D3230	REV. C
CHECKED	AS			SHEET 4 OF 5
MFG. APPR.	AS		TITLE	SCALE
APPROVED	AS		BASKET WEDGE ASSEMBLY	NTS
DE APPR.	AS			
DATE	09.01.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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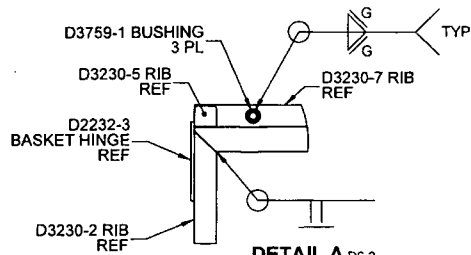
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

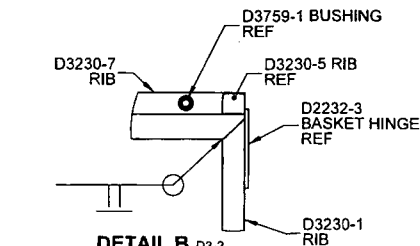
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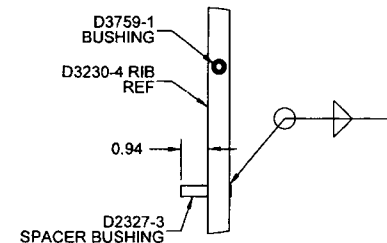
78259



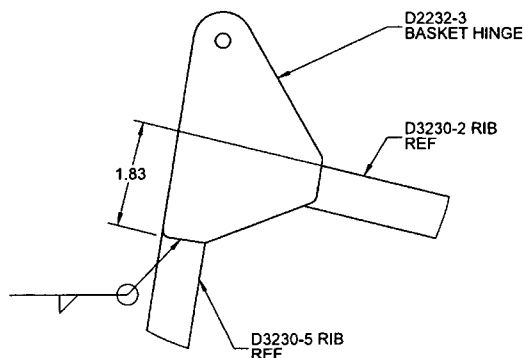
DETAIL A D6-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



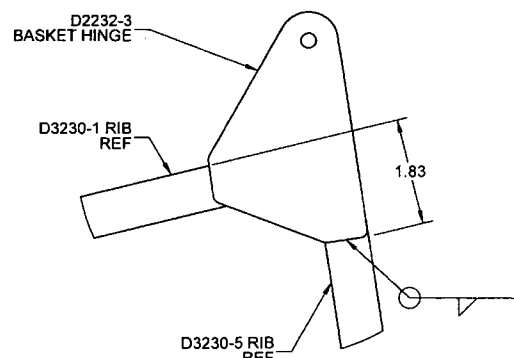
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MESH NOT SHOWN FOR CLARITY
SCALE 4X



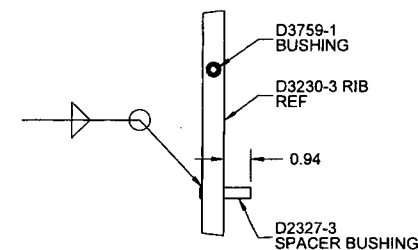
DETAIL C B6-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



DETAIL E C7-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X



DETAIL F C2-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X



DETAIL D B3-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X

RELEASED
09-218 P

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3230	SHEET 5 OF 5
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DE APPR.	AS	BASKET WEDGE ASSEMBLY	NTS
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